

SPLIT

Date: Tuesday, 23/09/2008 10:22:38 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD		
Job Number	: 42235		Part Number	: D35371		
Estimate Number	: 12712		Drawing Number	: D3537 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 23/09/2008	S.O. No. :	Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 05/10/2008		
Previous Run	: 41082		Qty:	50	Um:	Each
Written By	:					
Checked & Approved By	: JUL 08-9-23					
Comment	: Est Rev:A New Issue 07-02-14 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 Sheet .063	
		Comment: Qty.: 0 sf(s)/Unit Total : 6 sf(s) M304S16GA .063" 304 SS SHEET Batch: 109057 B 8-10-6	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C B 8-10-6 Prog Rev: C (60)	
		2-Deburr if necessary B 8-10-6	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE B 8-10-6	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK S.08/10/07 X60 (center)	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1 B 08/10/07 (60)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:38 AM
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Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat M109303,

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

X42

EL 8-10-22

7.0 QC10



VISUAL INSPECTION OF GROUND WELDS



coater

Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/22

X42

8.0 QC5



INSPECT WORK TO CURRENT STEP



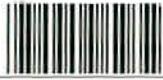
coater

Comment: INSPECT WORK TO CURRENT STEP

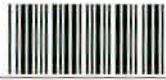
S 08/10/22

X42

9.0 POWDER COATING



POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 7:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:00AM

HJ 08-10-23

(X42)

10.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



(42)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-10-23

11.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

JH

08-10-23 (42)

12.0 QC21



FINAL INSPECTION/W/O RELEASE



08/10/23 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42235
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

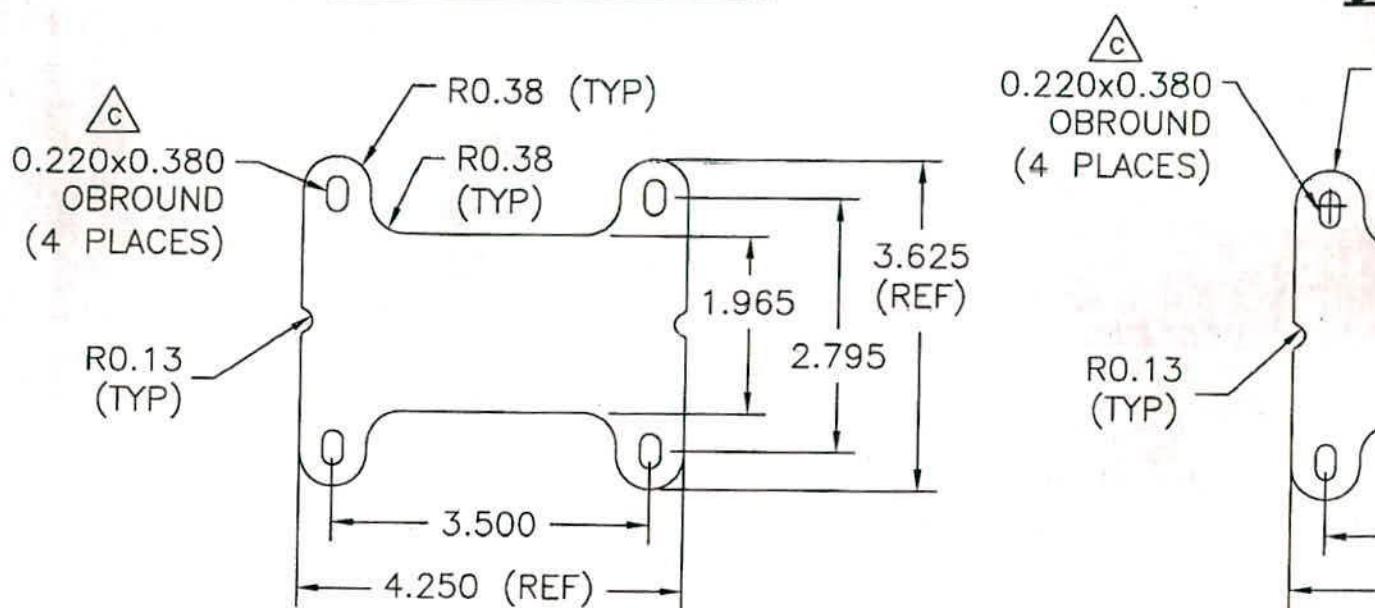
X First Article Prototype

Measured by:	<u>HB</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	<u>2-10-6</u>	Date:	<u>29/10/06</u>	Date:	N/A

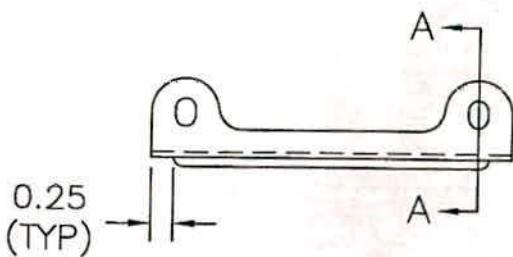
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>



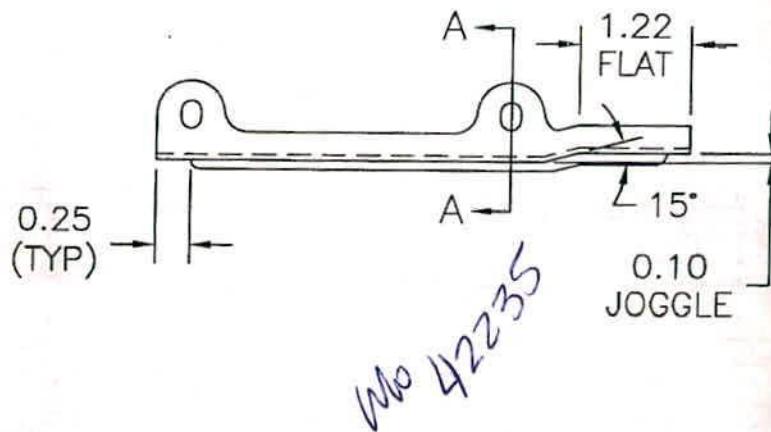
D3537-1F FLAT PATTERN



D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



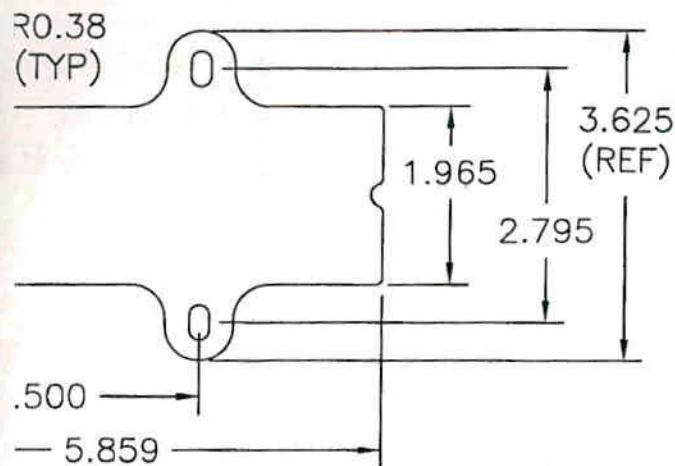
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

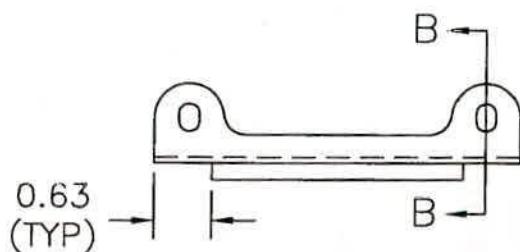


-3F FLAT PATTERN

8
)

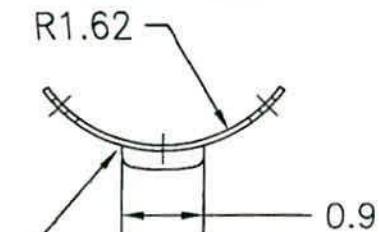


D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



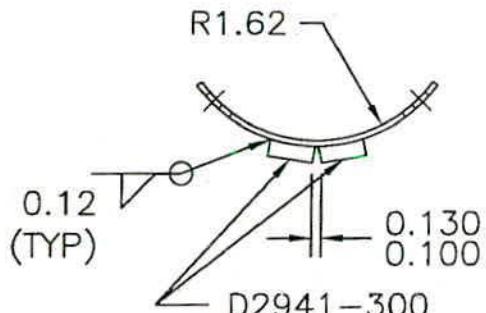
IGE (0.063 THICK)

SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

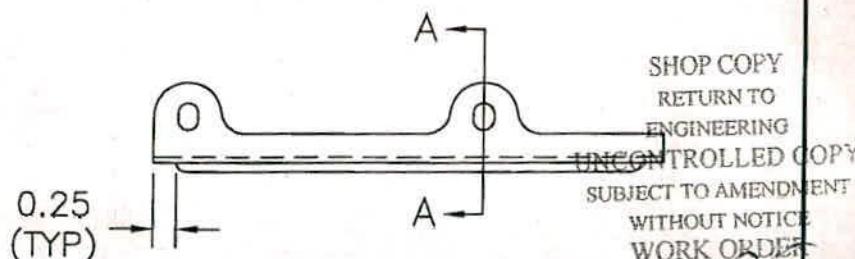
SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.08 PM
per ECN
962

D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 102235

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE

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DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CB	PH		
CHECKED	APPROVED		DRAWING NO. D3537
DATE			REV. C SHEET 1 OF 1
07.04.13			TITLE WEARPAD
			SCALE 1:2

